

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029467**Date Inspected:** 19-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QA) Joe Adame was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

In Process Visual Inspection

RWR-201208-005

The QA Inspector observed at random intervals, ABF/JV welder Mike Jimenez (WID-4671) performing carbon arc air gouging of ESW welds for defect removal on ESW weld designated as G. Location of excavation was noted as: Face A

Y= Original Y=4360mm, Excavation Y=4300~4900

L= 600mm

W= 40mm

D= 52mm

Prior to the repair work, ABF Quality Control (QC) Inspector Bernie Docena and the QA Inspector performed a UT verification of HAZ areas located 300 mm above and below to document discontinuities. The repair area will be reinspected after welding any indications noted will be reevaluated. QA/QC noted recordable indications at Y=4900 & Y=5000. After excavation and grinding to bright metal the QC Inspector and QA Inspector performed MT testing of the excavation to ensure all discontinuities were removed prior to welding. See TL-6027 & TL-6028 for additional information on items inspected on this date.

In Process Visual Inspection

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

RWR201206-044

ESW V-Face B

This QA observed, at random intervals, ABF/JV welder Chris Bruce (WID-8891) performing Shielded Metal Arc Welding (SMAW) with 4.0mm diameter E7018-MH4-R electrode and in accordance with ABF Welding Procedure Specification (WPS) ABF-WPS-D1.5-1000R-03. Prior to welding preheat was being maintained to over 300° degrees Fahrenheit using a Miller ProHeat 35 unit with heat induction blankets. Welding was performed on tower Electroslag Weld "ESW" designated as V- Face B, Original Y= 3550mm. During welding, ABF Quality Control Inspector (QC) Bernie Docena was observed monitoring the welding parameters throughout the shift.

Summary of Conversations:

Only general conversations with ABF/JV QC NDT personnel relevant to testing and work performed during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Adame,Joe	Quality Assurance Inspector
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Reviewed By:	Mertz,Robert	QA Reviewer
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